



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

D206-811-013
Job Sheet 171890



Tel (613) 632-5200

Part No: D206-811-013 **Job Qty:** 1 ea
Part Name: 206 A/B Replacement Engine Mount (S/N 2609 And Sub)



Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 2/9/18 **Job Tracking No:**
Due Date: 2/23/18 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**

Note: DWG REV B SHEET 9 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.06.19 AS PER IIN
REV.B DD VERF:JLM IPP REV:C 14.07.07 per chg002/ECN14-584 DD VERF:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea		2/23/18	0.00	0.00	Start Up Stores/Pkg-1			DAS 6 FEB 14 2018
110	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging1-3			DAS 6 FEB 14 2018
120	QC	1 pcs		2/23/18	0.00	0.00	QC4			DAS 6 FEB 14 2018
125	DC	1 pcs		2/23/18	0.00	0.00	DC			DAS 6 FEB 14 2018
130	Packaging	1 pcs		2/23/18	0.00	0.00	Packaging3-1			DAS 6 FEB 14 2018
170	QC21-FG	1 Ea		2/23/18	0.00	0.00	QC21			DAS 21 FEB 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4880-041	206A/B FWD Leg Assembly, LH	1 Ea (1 ea)	90-Start up Operation	
D4880-042	206A/B FWD Leg Assembly, RH	1 Ea (1 ea)	90-Start up Operation	
D4881-041	206A/B AFT Leg Assembly, LH	1 Ea (1 ea)	90-Start up Operation	
D4881-042	206A/B AFT Leg Assembly, RH	1 Ea (1 ea)	90-Start up Operation	
D4882-041	206A/B Leg Assembly LH	1 Ea (1 ea)	90-Start up Operation	
D4882-042	206A/B Leg Assembly RH	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4880-041	1	0	0
	D4880-042	1	4	0
	D4881-041	1	0	0
	D4881-042	1	5	0
	D4882-041	1	1	0
	D4882-042	1	2	0

Part Specifications

Specifications could not be found.

893

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order Part NCR Date : Container No: S042437 Part: D206-811-013 Serial No/Batch: S042437 Revision: IIN-D206-811-1 Inspector: Date: 02/14/18 14:53 PM	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; padding: 5px;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 25%; padding: 5px;"> ss tube ☐ all Fab ☐ nishing ☐ roperty ☐ </td> <td style="width: 25%; padding: 5px;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 25%; padding: 5px;"> Engineering ☐ Quality ☐ Other ☐ </td> <td style="width: 25%;"></td> </tr> <tr> <td colspan="3" style="height: 40px; vertical-align: bottom; padding: 5px;"> position </td> <td style="padding: 5px;"> MRB (QSI042) Approval </td> </tr> <tr> <td colspan="3" style="height: 40px;"></td> <td style="padding: 5px;"> Completed By </td> </tr> <tr> <td colspan="3" style="height: 40px;"></td> <td style="padding: 5px;"> Lead hand / Supervisor Approval Verification </td> </tr> <tr> <td colspan="3" style="height: 40px;"></td> <td style="padding: 5px;"> QC / QA Coordinator Approval </td> </tr> </table>	AGAINST DEPARTMENT/PROCESS				ss tube ☐ all Fab ☐ nishing ☐ roperty ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐		position			MRB (QSI042) Approval				Completed By				Lead hand / Supervisor Approval Verification				QC / QA Coordinator Approval
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OTHER :																									



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Master Unit 000893

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Containers on Master Unit 000893				
Serial No	Part No	Customer Part No	Status	Quantity
S041373	D4880-041	D4880-041	Allocated	1
S042436	D4880-042	D4880-042	Allocated	1
S041443	D4881-041	D4881-041	Allocated	1
S042435	D4881-042	D4881-042	Allocated	1
F163967	D4882-041		Allocated	1
S042434	D4882-042	D4882-042	Allocated	1

Table 2. – Fastener Torque

Fastener Type	Torque (in-lbs)	Torque (N*m)
1/4-28 	90	10.2
5/16-24 3/8-24 	125-145	14.1-16.4

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the D206-811-011/-013 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-811-011 REPLACEMENT ENGINE MOUNT KIT <i>(Bell 206A/B Series S/N 661-671, 716-2608, 39998 and Sub)</i>	1.9 lb 0.86 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	135.5 in 3.44 m	257 in-lb 3.0 m-kg
D206-811-013 REPLACEMENT ENGINE MOUNT KIT <i>(Bell 206A/B Series S/N 2609 and Sub)</i>	1.7 lb 0.77 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	135.5 in 3.44 m	230 in-lb 2.6 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D206-811-011	REPLACEMENT ENGINE MOUNT KIT <i>(206A/B Series S/N 661-671, 716-2608, 39998 and Sub)</i>
	X	D206-811-013	REPLACEMENT ENGINE MOUNT KIT <i>(206A/B Series S/N 2609 and Sub)</i>
1		D4878-041	FWD LEG ASSY, LH
1		D4878-042	FWD LEG ASSY, RH
1		D4879-041	AFT LEG ASSY, LH
1		D4879-042	AFT LEG ASSY, RH
1		D4928-041	LEG ASSY, LH
1		D4928-042	LEG ASSY, RH
	1	D4880-041	FWD LEG ASSY, LH
	1	D4880-042	FWD LEG ASSY, RH
	1	D4881-041	AFT LEG ASSY, LH
	1	D4881-042	AFT LEG ASSY, RH
	1	D4882-041	LEG ASSY, LH
	1	D4882-042	LEG ASSY, RH